

92070

Page 1

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

6

6

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

[illegible]

Work Order ID 92070

October-22-12 3:18:02 PM

92070

Page 2

Item ID: 647.1810

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Nose Door Doubler

Stop ***NS2***

Start Date: 22/10/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 05/11/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				6			
140 *140* Outsource4 Outsource process - Anodize	Outsource process-Anodize per QSI017 4.1.10.1 Memo ISSUE P/O: 18304 HARD ANODIZE, COLOR BLACK AS PER DWG.(SEE NOTE 2)	0.00 0.00							12-10-01
150 *150* Packaging Packaging	Receive & Inspect for Damage & Mat'l Certs Memo	0.00 0.00							12/10/12 (6)

92070

Page 3

N900040100

Setup Start *NS1*

Stop ***NS2***

Start Date: 22/10/2012 **Start Qty:** 6.00 ***6***

Required Date: 05/11/2012 **Req'd Qty:** 6.00 ***6***

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.00				6			DAS 05 9-89 12 11 07
Quality Control									
170		0.00							
170									
SprayPaint	Memo	0.00				6	0	0	AP
Spray Painting	PRIME IAW MIL-P-23377J TYPE I CLASS N AS PER DWG. (SEE NOTE 2)								12-11-17
	CARDINAL 4860-50 PRIMER BATCH: <u>122543</u>								
180	QC14- Inspect Spray Paint	0.00							
180									
QC	Memo	0.00							DAS 16 9-89 12/11/15
Quality Control						76			

Work Order ID 92070

October-22-12 3:18:02 PM

92070

Page 4

Item ID: 647.1810

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Nose Door Doubler

Stop ***NS2***

Start Date: 22/10/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 05/11/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: <u>ST</u>	0.00							
190									
Packaging	Memo	0.00							
Packaging	***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***								
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

12/11/2012 (6)12/11/2012

MF

12-11-24

Picklist Print

October-22-12 3:18:07 PM

Page 1

Work Order ID: 92070

92070

Parent Item: 647.1810

647 1810

Parent Item Name: Nose Door Doubler

Start Date: 22/10/2012

Required Date: 05/11/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 12.10.03 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			110	sf	40.4700	0.153	0.9663 16			

M2024T3S 063

2024-T3 .063 sheet

**

1.0

Jm 12-11-1

Location

Loc Qty

Loc Code

MAT022

40.47

119916

0.1

121197

16.32

123096

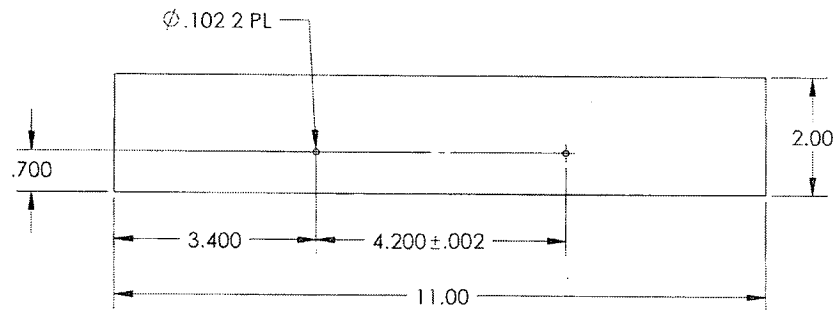
24.05

123096

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NOTES:

1. MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4
2. FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK; CARDINAL 4860-50 PRETREATMENT PRIMER PRIME IAW MIL-P-23377J TYPE I CLASS N
3. DEBURR AND BREAK ALL SHARP EDGES
4. IDENTIFY IAW MPP-120



.063

647.1810

SEVEN
RETURNED
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENTS

WITHOUT NOTICE
WORK ORDER
NO. 92070 ML5
12-10-22

		647.1818	NOSE DOOR SPACER	△	△
		647.1817	SUPPORT, RH	△	△
		647.1816	SUPPORT, LH	△	△
		647.1815	GUSSET, RH	△	△
		647.1814	GUSSET, LH	△	△
		647.1813	ANGLE	△	△
		647.1812	SHIM	△	△
		647.1811	SPACER	△	△
		647.1810	NOSE DOOR DOUBLER	△	△
	FIND #	PART #	DESCRIPTION	MATL	SPEC.
QTY			PARTS LIST		
NEXT ASSY (S)			APICAL INDUSTRIES		
647.1800			2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300		
ORIGINAL DATE REVISION DESIGNED BY CHECKED BY DATE APPROVED BY DATE WHERE DIMENSIONS SPECIFIED UNLESS OTHERWISE SPECIFIED 2 PLACE DECIMALS 1.01 3 PLACE DECIMALS 1.000 ANGLE 1/2°			SHEETMETAL		
DATE SCALE PART NAME			647.1800		
			SHEET 1 OF 7		

ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED
 ALL DIMENSIONS ARE TO CENTER UNLESS OTHERWISE SPECIFIED
 THE USE OF DIMENSIONS ON THIS DRAWING IS FOR INFORMATION ONLY

.25 X 45.0°
 4 PL

1.00

3.63

.063

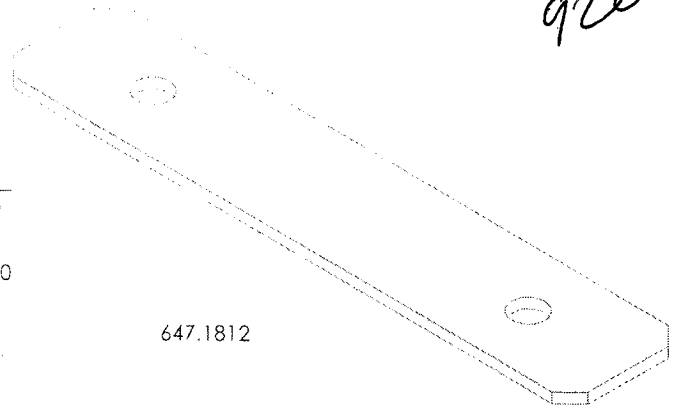
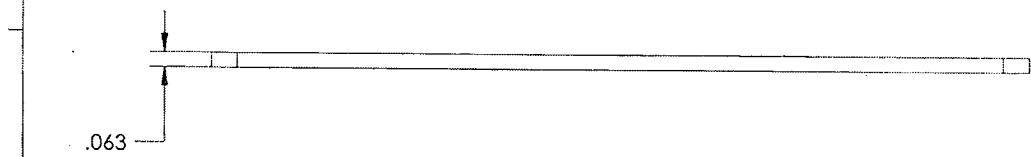
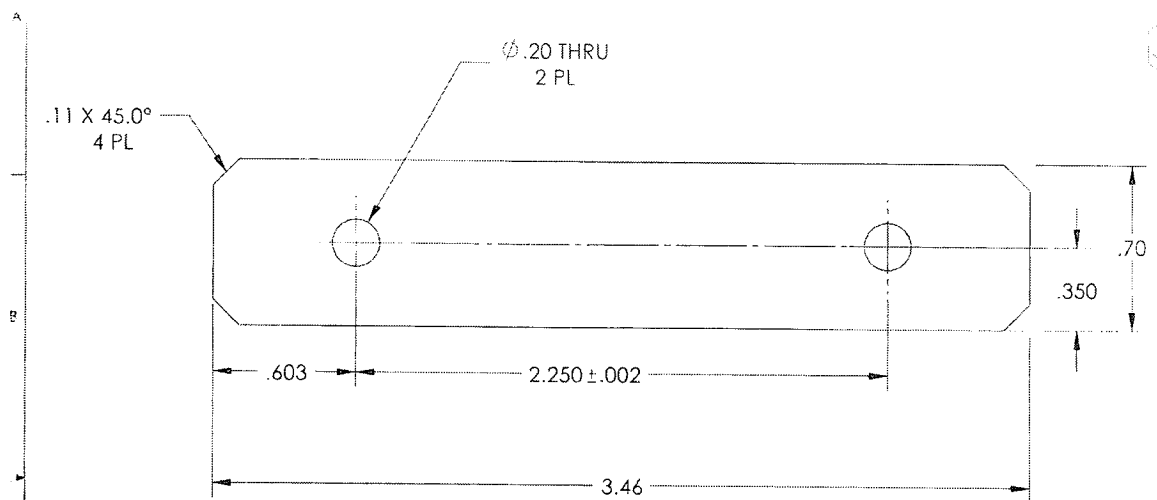
92070

647.1811

ORIGINAL DATE MODIFIED DATE DRAWN BY CHECKED BY DESIGNED BY DRAWING APPROVAL P. BRAY BRAY CONTACT NO.		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE FINISHES ARE SPACED DIMENSIONS ARE ANGLES ARE		SHEETMETAL	
REV.	DATE	BY	REV.
B	07/17/16	647.1800	N/C
SCALE: NONE		SHEET 2 OF 7	

ALL DIMENSIONS UNLESS OTHERWISE SPECIFIED ARE IN INCHES
 APICAL INDUSTRIES 414 PLYMOUTH STREET SUITE 200 OCEANSIDE, CA 92056
 ALL DIMENSIONS ARE TO CENTER UNLESS OTHERWISE SPECIFIED

92070



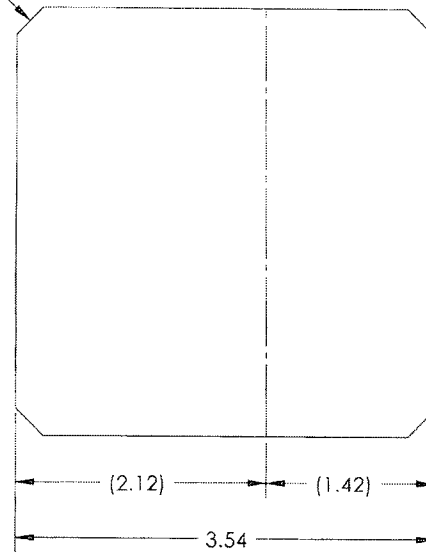
647.1812

DATE: 01/11/01 DRAWN BY: J. BROWN CHECKED BY: J. BROWN DESIGNED BY: J. BROWN MANUFACTURED BY: J. BROWN MATERIAL: 304 SS FINISH: POLISHED		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
SHEETMETAL		SCALE: NONE	
SHEET: 3 OF 7	DWG NO: 647.1800	REV: N/C	DATE: 01/11/01

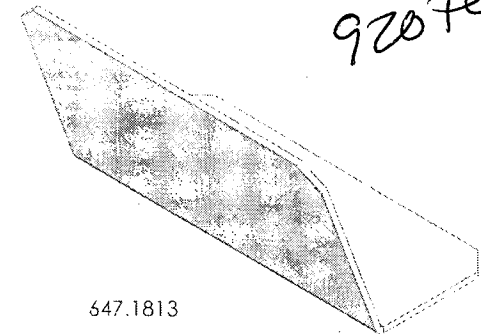
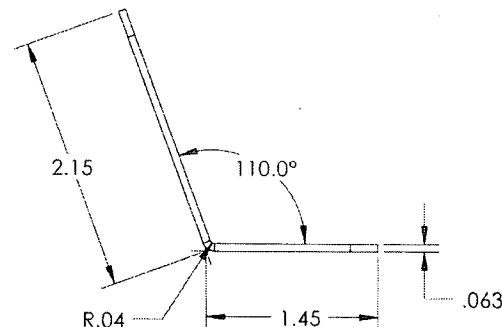
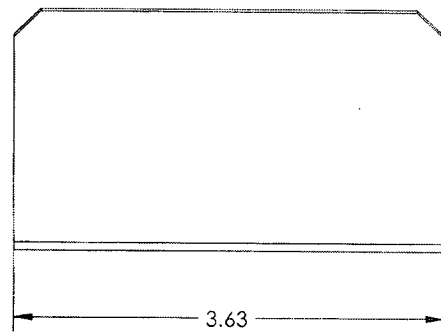
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92070

.23 X 45.0°
4 PL



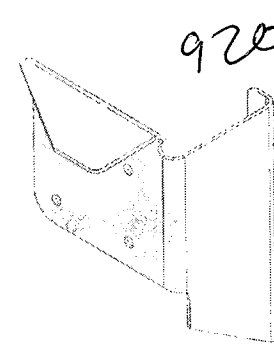
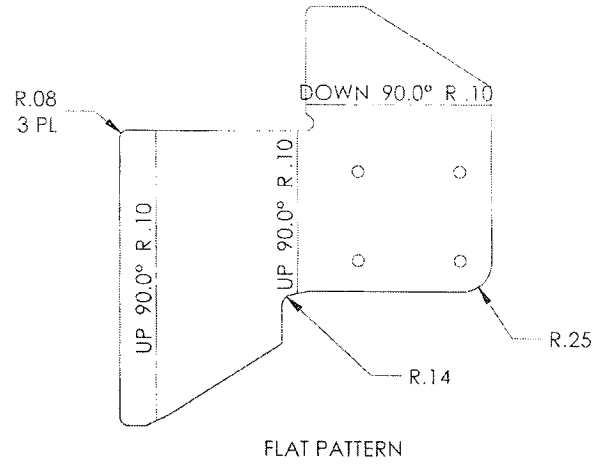
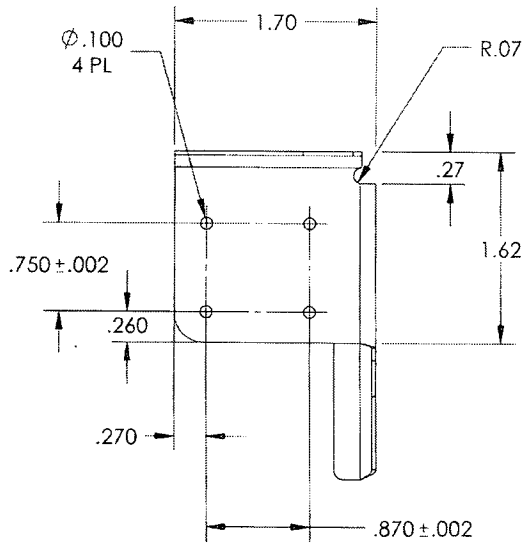
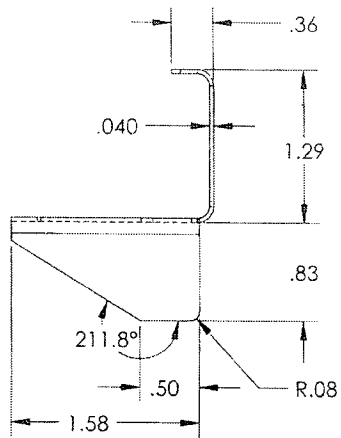
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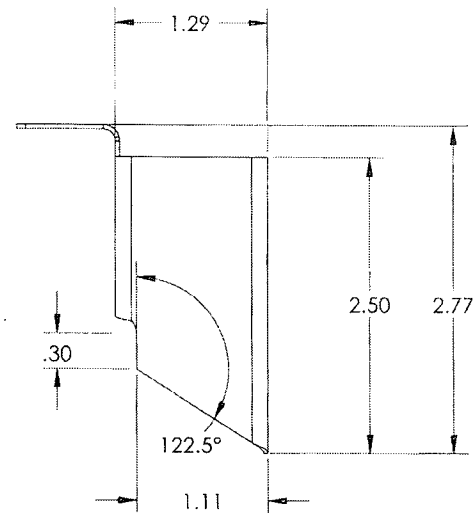
647.1813

ORIGINAL DATE (C/D/DA/YY) 01/16		DESIGNER P. BRANCO	
DRAWN BY P. BRANCO		CHECKED P. BRANCO	
DATE OF APPROVAL P. BRANCO		DATE OF APPROVAL P. BRANCO	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES DECIMALS ARE PLACES DECIMALS 101 SPECIAL DIMENSIONS 1000 ATTACHED E.C.		APICAL INDUSTRIES 2408 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300 SHEETMETAL	
REV	CASE CODE	DWG. NO.	REV.
B	07M16	647.1800	14/C
SCALE: NONE		SHEET 4 OF 7	

ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED
APICAL INDUSTRIES AND PERSONNEL SHALL BE RESPONSIBLE FOR THE QUALITY OF THE WORK
THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS REQUIRED



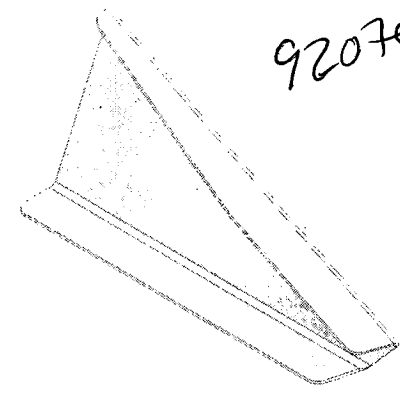
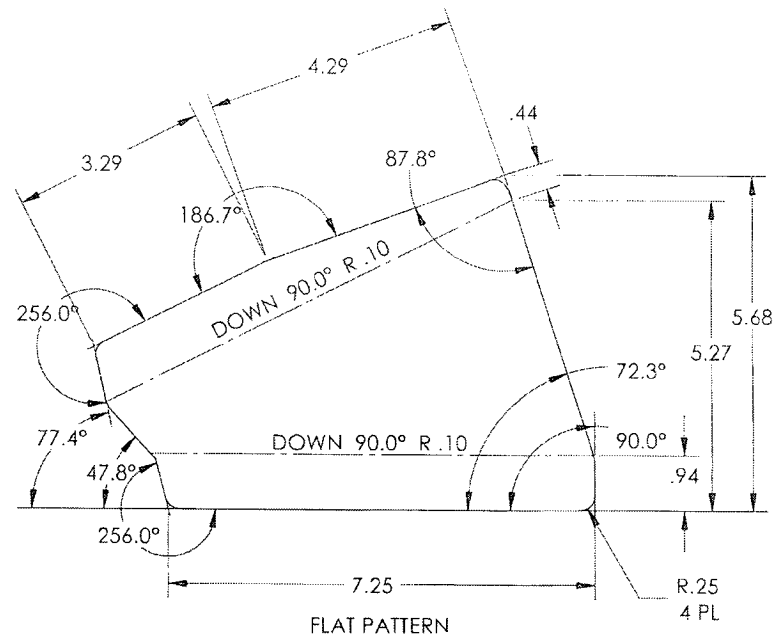
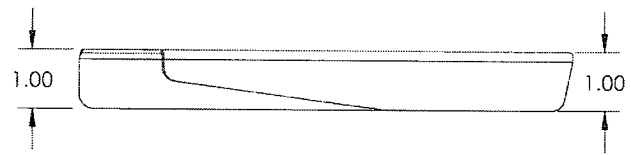
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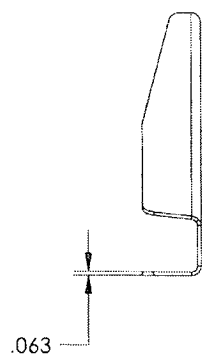
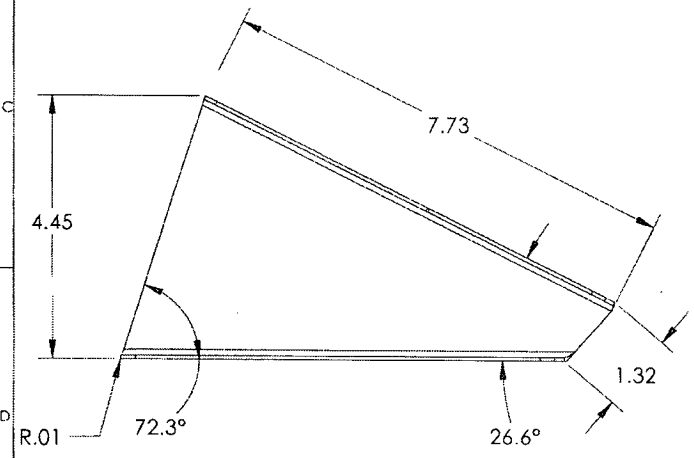
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DRAWN BY J. BRAY	CHECKED J. BRAY	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
DRAWING APPROVAL J. BRAY	REVISION 01/01/02	SHEETMETAL	
CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS DECIMALS FRACTIONS DECIMALS ANGLES ± .1°		SIZE (CASE CODE) DRWG NO. B 01/01/02 647.1800	REV. N/C
SCALE: NONE		SHEET 5 OF 7	

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 ALL DIMENSIONS ARE TO CENTER UNLESS OTHERWISE SPECIFIED
 THE MATERIAL SPECIFICATION IS TO BE DETERMINED BY THE FABRICATOR

92070



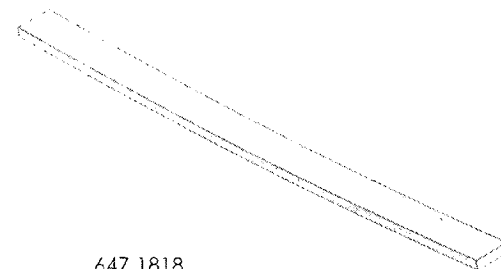
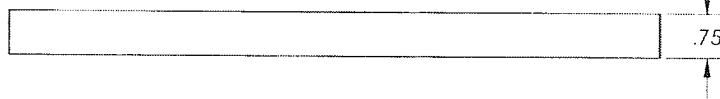
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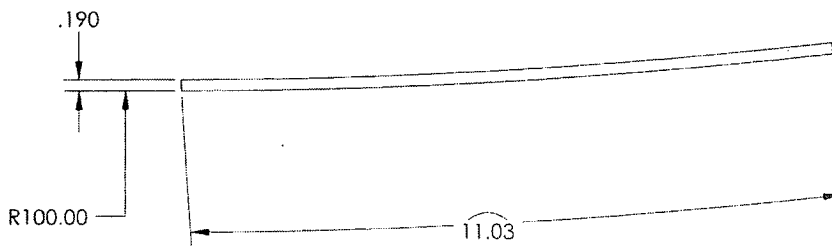
PARTIAL DATE DRAWN BY: CHECKED (GARDNER) P. BRAVO REVISED APPROVAL P. BRAVO DATE:		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-3300	
SHEETMETAL		SHEET 6 OF 7	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES DECIMALS .001 FRACTIONS 1/16 ANGLES .1°	SUB: 07/10/26 DWG. NO: 647.1800	REV: 14/C	SCALE: NONE

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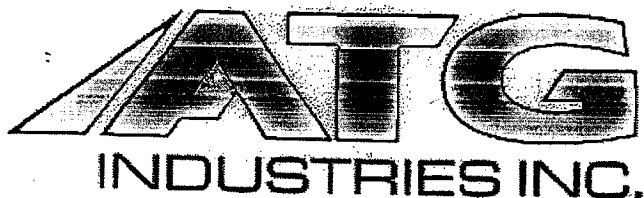
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647.1818



DRAWN BY: J. B. BAYO CHECKED BY: J. B. BAYO DATE: 07/12/06		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760)724-5300	
PROJECT: 647.1800 SHEET: 7 OF 7		SHEETMETAL	
WHEN CHANGES ARE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1 PLACE DECIMALS ±.01 2 PLACE DECIMALS ±.005 3 PLACE DECIMALS ±.001	SET: B CASE CODE: 07/12/06 SCALE: NONE	DIMS: 647.1800 SHEET: 7 OF 7	REV: N/C



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 62027

Date: 05-Nov-12

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
1 lot	Part: ASST 10 PCS 646.9813 10 PCS 646.9811 10 PCS 646.9812 10 PCS 646.9812 2 PCS 646.9811 15 PCS 646.4711 15 PCS 647.4716 15 PCS 647.4712 15 PCS 647.4717 15 PCS 647.4714 15 PCS 647.4715 15 PCS 647.4718 HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 Job: 20120674	Rev:	Line:
1 lot	Part: ASST 7 PCS 647.1810 14 PCS 647.1811 91 PCS 647.1812 2 PCS 647.1612 HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 Job: 20120673	Rev:	Line:
Certificate of Conformance			



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 62027

Date: 05-Nov-12

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms

Ship Via

Quantity

Description

A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.

ISO 9001 : 2008 REGISTERED
ATG SALES-2010 TERMS APPLY

DATE: 5/12/12

CERTIFIED SIGNATURE: 

RECEIVER SIGNATURE: _____